



Work Order ID 64549


Wednesday, December 08, 2010 10:11:58 A

Page 1

Item ID:	D3315-3	Accept		Setup	Start	
Revision ID:						
Item Name:	Wearplate				Stop	
Start Date:	12/8/2010	Start Qty:	2.00		Cust Item ID:	
Required Date:	12/22/2010	Req'd Qty:	2.00		Customer:	
Reference:						


Approvals:	Process Plan:	<u>PL</u>	Date:	<u>10-12-8</u>	Tooling:		Date:		Run	Start	
	QC:		Date:		SPC (Y/N):		Date:			Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3315	Rev B								


100		0.00							
	FLOW WATER JET								
Waterjet	Memo	0.00							
FLOW CNC Waterjet	1-Cut as per Dwg D3315 <input type="checkbox"/> Dwg Rev: <u>B</u> <input type="checkbox"/> Prog Rev: <u>B</u> <input type="checkbox"/> 2-								
1010 .060	Deburr if necessary								

B10-12-23

(2)

110		0.00							
	QC2- Inspect parts off machine FAI/FAIB								
QC	Memo	0.00							
Quality Control									

B10-12-23

120		0.00							
	QC8- Inspect parts - second check								
QC	Memo	0.00							
Quality Control									

5012/23

(x2)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 64549

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Page 2

Item ID: D3315-3

Accept

Revision ID:

Item Name: Wearplate

Start Date: 12/8/2010 Start Qty: 2.00

Required Date: 12/22/2010 Req'd Qty: 2.00

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

0.00



Brake NC

NC BRAKE

Memo

0.00

Brake NC

Form using DT8179 Die and DT8157 as per Dwg D3315 Rev: B

SO 11/01/03

(2)

140

0.00



QC

QC6- Inspect dimensions to drawing

Memo

0.00

Quality Control

8 11/08/03

(+2)

3

150

0.00



Large Fab

Large Fab

Memo

0.00

Large Fab

Weld hard surface using D3315-3T3 as per QSI 004 and Dwg D3315 Rev:

☐ Qty Part Number Description Batch ☐ A/R
N/A 7560 Hardcoat Rod M115552

EL

11-1-11

(+2)

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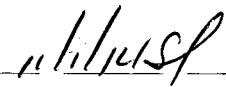

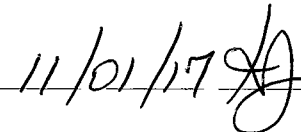
Work Order ID 64549

Wednesday, December 08, 2010 10:11:58 A

Page 4

Item ID: D3315-3 Accept  Setup Start 
Revision ID: Stop 
Item Name: Wearplate
Start Date: 12/8/2010 Start Qty: 2.00  Cust Item ID:
Required Date: 12/22/2010 Req'd Qty: 2.00  Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start 
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop 

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190  QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00				2	0	11/01/14	
200  Packaging Packaging	Packaging Memo Identify on inside surface using a permanent fine point marker with the following: <input type="checkbox"/> TCCA-PDA, Dart Aerospace Ltd. <input type="checkbox"/> P/N: D3315-3, B/N: BXXXXX <input type="checkbox"/> For Product Eligibility see PDA04-17 <input type="checkbox"/> and Stock <input type="checkbox"/> Location: <u>496</u>	0.00 0.00						11/01/14	
210  QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00						11/01/17	

11/01/14

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NOTE: Date & initial all entries

Picklist Print

Wednesday, December 08, 2010 10:12:03 AM

Page 1

Work Order ID: 64549

Parent Item: D3315-3

Parent Item Name: Wearplate



Start Date: 12/8/2010

Required Date: 12/22/2010

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP: A 05.05.12 New issue KJ/JLM
IPP Rev:B As per Rev B 06-03-24 JLM
IPP Rev:C Now on Waterjet 07-07-11 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M1010S16GA 		Purchased	No			100	sf	84.5250	2.296	4.833684			
1010/1025 sheet 16GA													

10-12-23

Location

Loc Qty

Loc Code

MAT19

84.525

111410

84.525

111410

2

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	61549
Description: Wearplate		Part Number:	D3315-3
Inspection Dwg: D3315 Rev: B		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
62.75	+/-0.030	62.75	x		Y 100%	
58.094	+/-0.010	58.094	2		T	
51.368	+/-0.010	51.368	2		T	
44.531	+/-0.010	44.531	2		T	
37.719	+/-0.010	37.719	2		T	
30.375	+/-0.010	30.375	2		T	
24.188	+/-0.010	24.188	2		T	
18.875	+/-0.010	18.875	2		T	
17.375	+/-0.010	17.375	2		T	
10.594	+/-0.010	10.594	1		T	
5.375	+/-0.010	5.375	2		T	
0.875	+/-0.010	.877	2		V 100%	
1.62	+/-0.030	1.62	2		V	
5.214	+/-0.010	5.214	2		V	
4.402	+/-0.010	4.404	2		V	
3.550	+/-0.010	3.555	2		V	
Ø0.300	+0.006/-0.001	.301	3		V	
Ø0.266 x 0.450	+/-0.010	265 x 450	2		V	

Measured by:	WB	Audited by:	S	Prototype Approval:	N/A
Date:	10-12-23	Date:	10/12/23	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	08.01.22	New Issue	KJ/EC/DD	DA

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

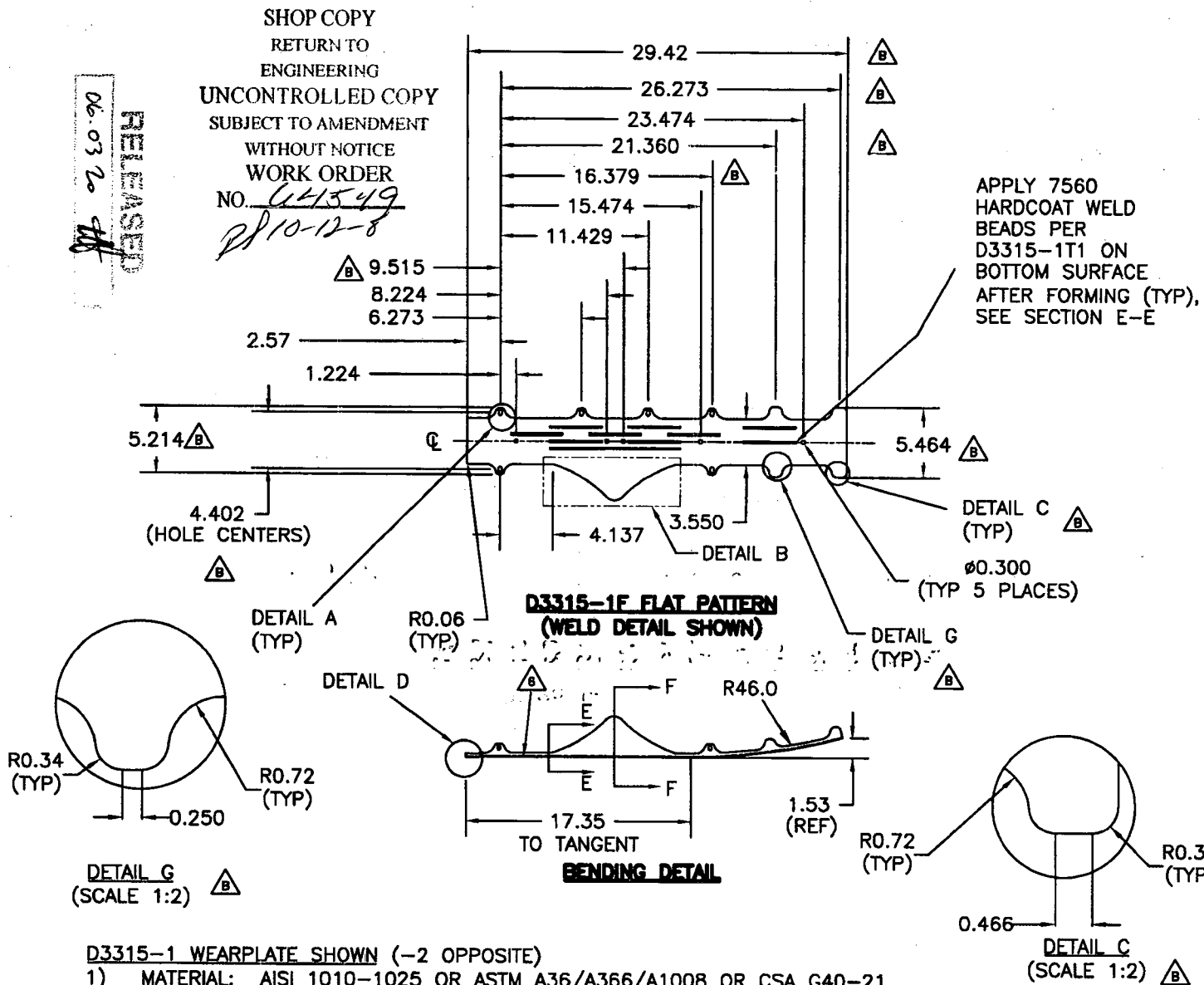
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN	DRAWN BY	DART AEROSPACE LTD
04	04	HAMKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO.
<i>[Signature]</i>	<i>[Signature]</i>	D3315
DATE	TITLE	SCALE
06.01.31	WEARPLATE	1:12
A	04.09.10	NEW ISSUE
B	06.01.31	UPDATE DIMENSIONS



- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES STEEL 16 GAUGE (0.060 THICK)
- 2) FINISH: POWDER COAT GREY SANDTEX (REF.4.3.5.6) PER DART QSI 005 4.3
- 3) WELD PER DART QSI 004
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) IDENTIFY ON INSIDE SURFACE AS INDICATED
*TCCA-PDA, DART AEROSPACE LTD., P/N D3315-X
B/N BXXXXX, FOR PRODUCT ELIGIBILITY SEE PDA05-17"

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

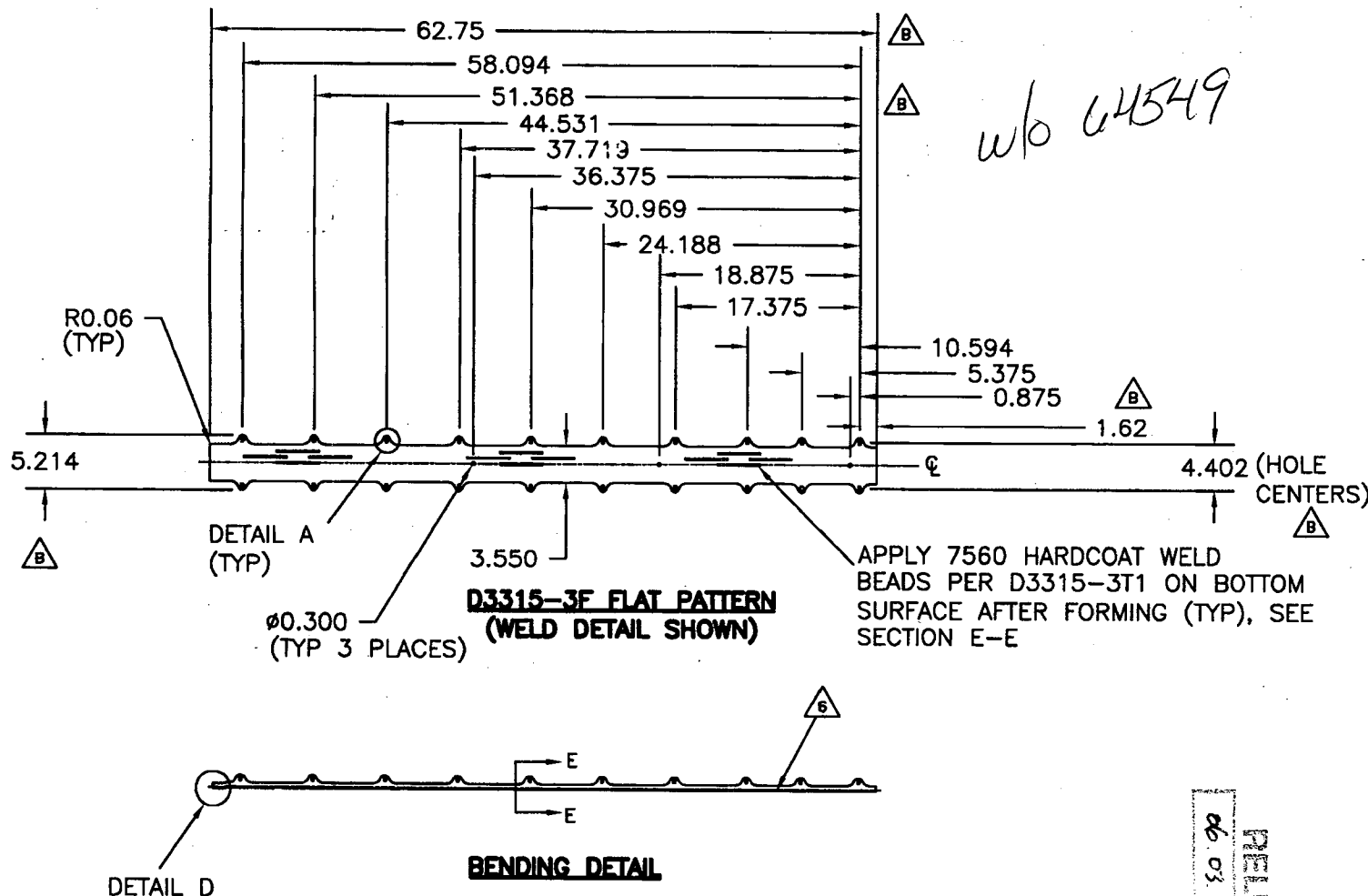
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN	04	DRAWN BY	04	DART AEROSPACE LTD
CHECKED	<i>[Signature]</i>	APPROVED	<i>[Signature]</i>	HAMKESBURY, ONTARIO, CANADA
DATE	06.01.31	TITLE	D3315	REV. B
		WEARPLATE		SHEET 2 OF 4
				SCALE
				1:18



D3315-3 WEARPLATE SHOWN (-4 OPPOSITE)

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES STEEL 16 GAUGE (0.060 THICK)
- 2) FINISH: POWDER COAT GREY SANDTEX (REF.4.3.5.6) PER DART QSI 005 4.3
- 3) WELD PER DART QSI 004
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) IDENTIFY ON INSIDE SURFACE AS INDICATED
"TCCA-PDA, DART AEROSPACE LTD., P/N D3315-X
B/N BXXXXX, FOR PRODUCT ELIGIBILITY SEE PDA05-17"

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

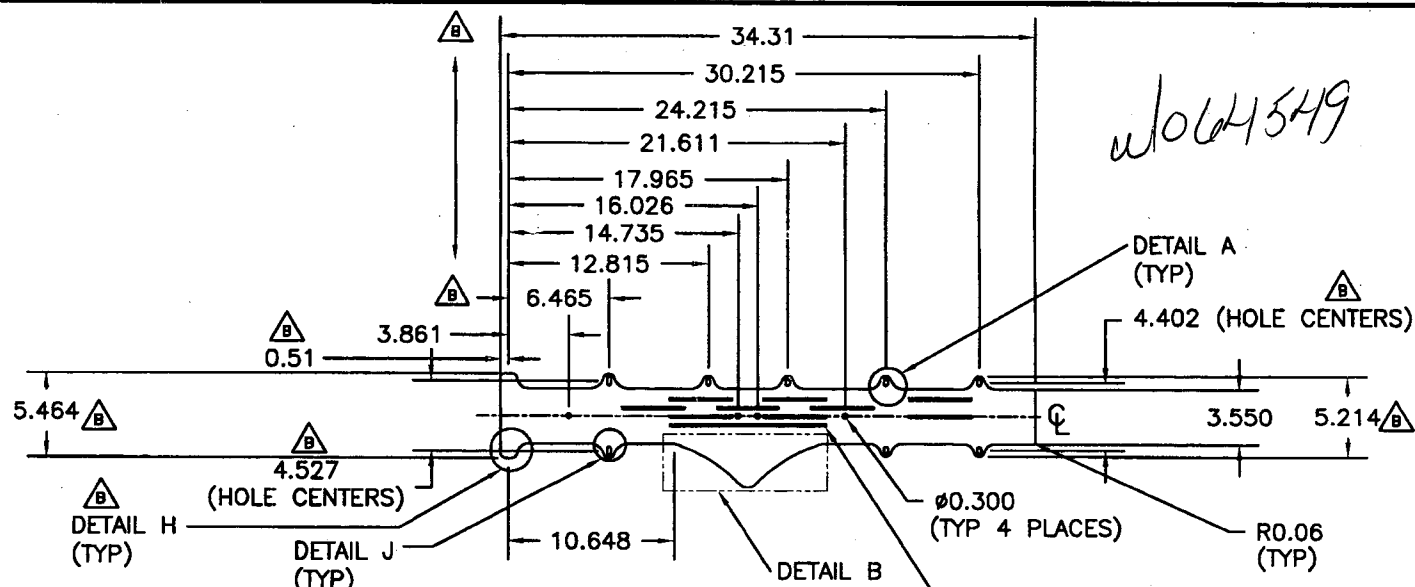
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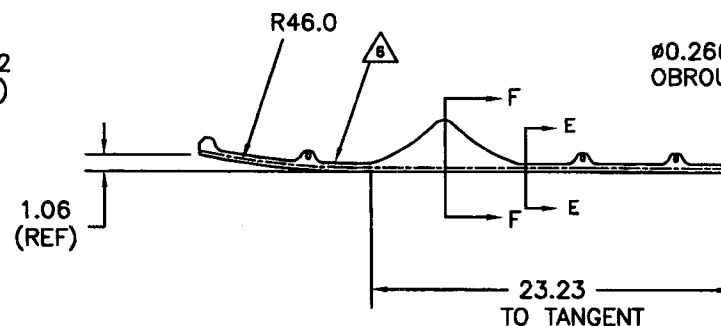
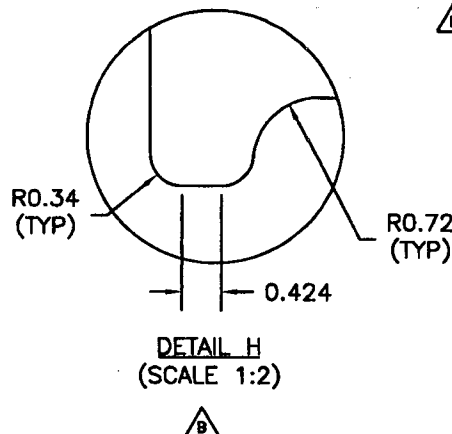
NOTE: Date & initial all entries

DART

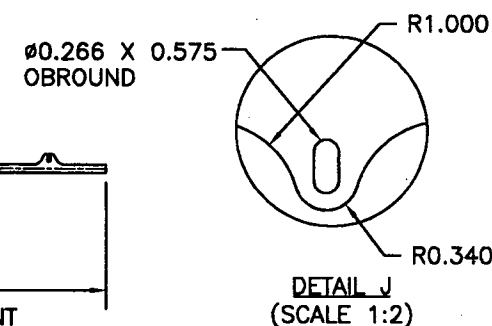
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CHECKED		APPROVED		HAWKESBURY, ONTARIO, CANADA
DATE	06.01.31	TITLE	D3315	REV. B
		WEARPLATE	1:12	SHEET 3 OF 4



**D3315-5F FLAT PATTERN
(WELD DETAIL SHOWN)**



BENDING DETAIL



D3315-5 WEARPLATE SHOWN (-6 OPPOSITE)

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES STEEL 16 GAUGE (0.060 THICK)
- 2) FINISH: POWDER COAT GREY SANDTEX (REF.4.3.5.6) PER DART QSI 005 4.3
- 3) WELD PER DART QSI 004
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSION ARE IN INCHES
- 6) IDENTIFY ON INSIDE SURFACE AS INDICATED
"TCCA-PDA, DART AEROSPACE LTD., P/N D3315-X
B/N BXXXXX, FOR PRODUCT ELIGIBILITY SEE PDA05-17"

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RELEASED
06 03 20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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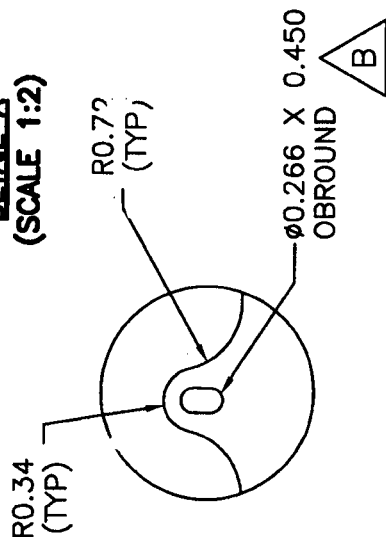
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DATE 06.01.31	TITLE WEARPLATE		SCALE NTS

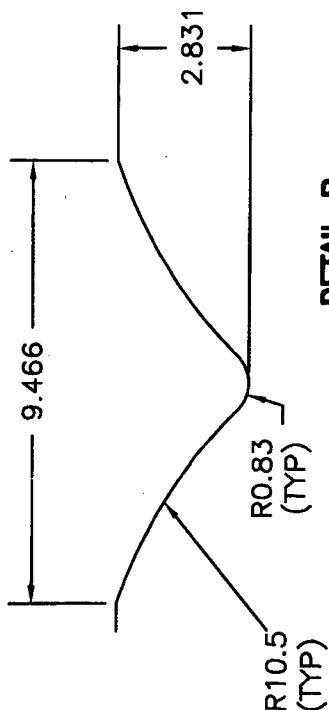
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(SCALE 1:2)



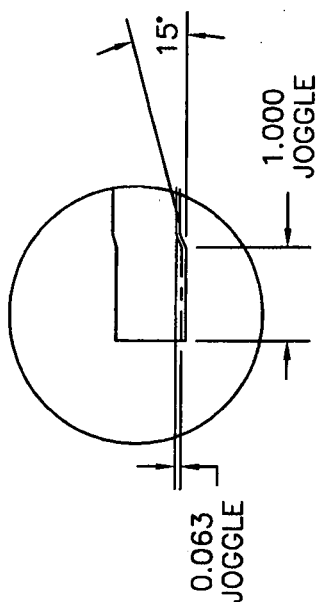
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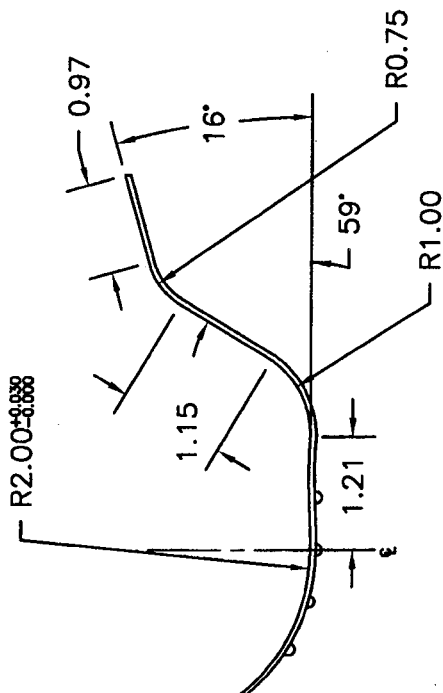
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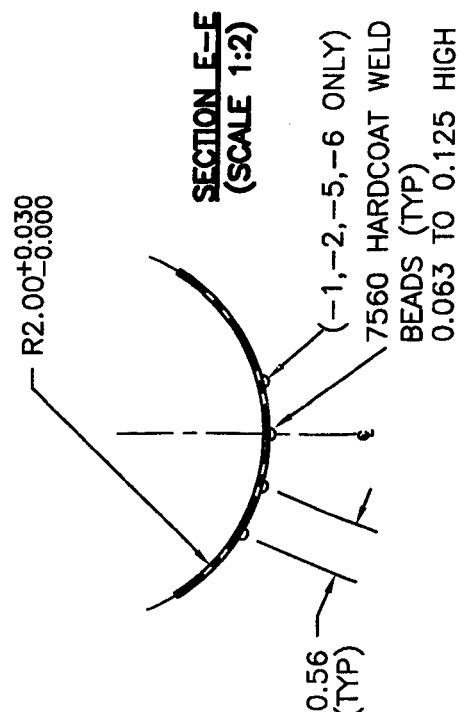
DETAIL B
(SCALE 1:4)



DETAIL D
(SCALE 1:2)



SECTION F-F
(SCALE 1:2)



SECTION E-E
(SCALE 1:2)

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